

Work Order ID 60918

Monday, July 26, 2010 3:32:26 PM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 7/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

6-7-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: *109213*

6- grind weld flush where indicated on dwg

SAD 10-07-28

2

PL 10-07-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

② 10.07.29

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sider 12

④ 2

-042

150

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

B/C
(WA)

SAD

10-07-29

Cpl 10.07.28

W/O:		WORK ORDER CHANGES						
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Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/29

10-7-29
(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, July 26, 2010 3:32:32 PM

Page 1

Work Order ID: 60918

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured No

100

Each

31.0000

1

2

Spacer Bushing

Location

Loc Qty

Loc Code

WA

31

58406

1

58974

1

59980

9

60320

20

M304TS0.750W.065

Purchased

No

100

f

617.0387

1.7808

3.749053

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

1.4628

112398

0

114482

1.4628

WA

615.575885

114520

57.681285

115274

557.8946

3.7491

20 SAV 10-07-28

Cpl 10-07-28

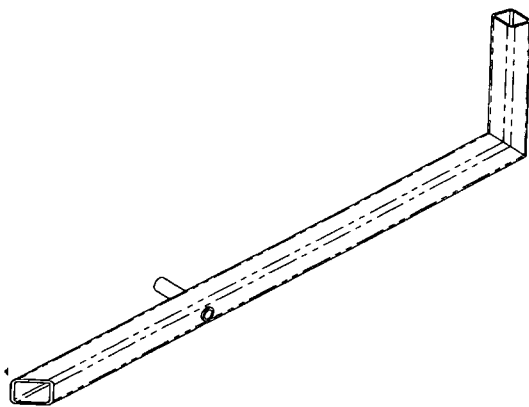
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

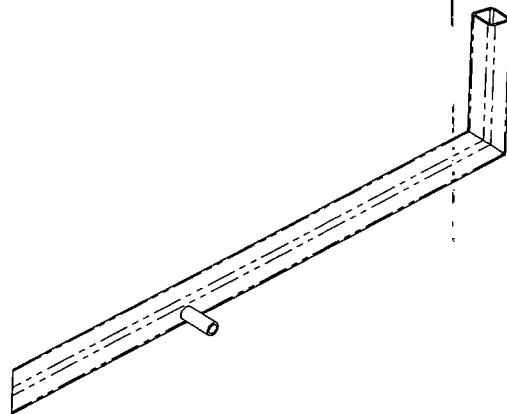
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D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60918
Df10-726

RELEASED
08/11/18 MB

A		NEW ISSUE		MB	08.09.24
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	D3836	REV. A	
MFG. APPR.		TITLE	RIB ASSY (BASKET LID)	SHEET 1 OF 3	
APPROVED		SCALE		NTS	
DE APPR.		DATE 08.09.24			

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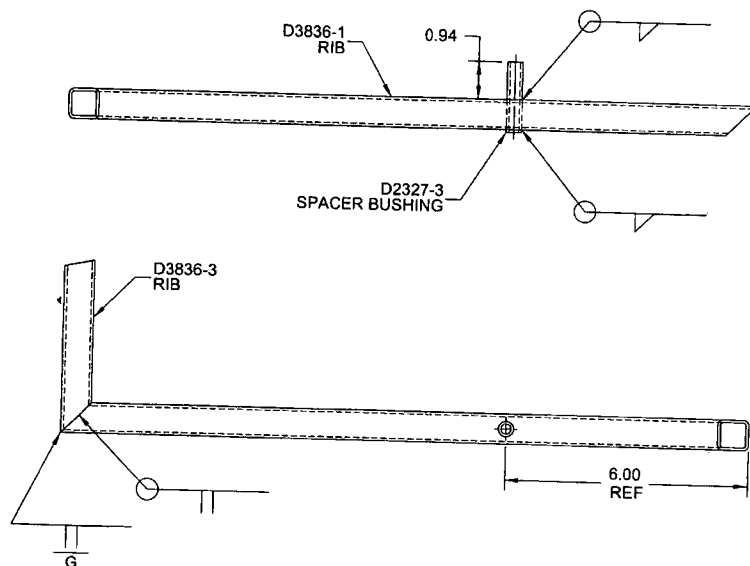
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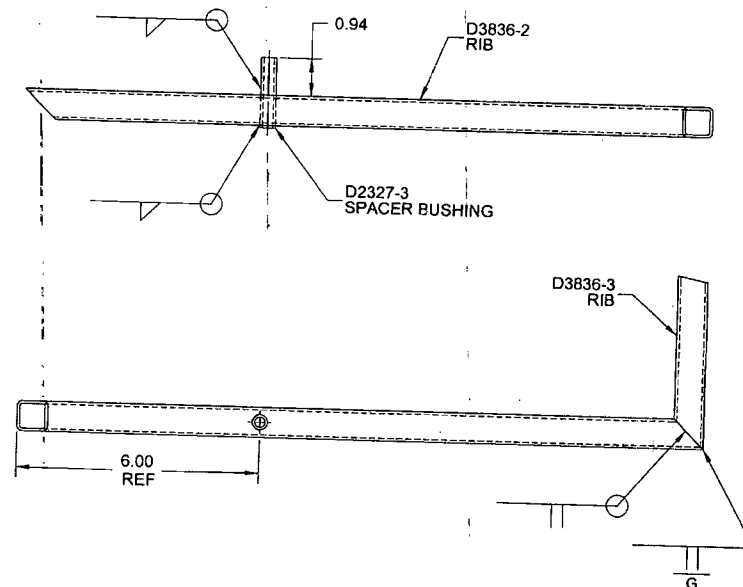
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NOTE: Date & initial all entries



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

60918

RELEASED
08/11/81

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3836
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE NTS
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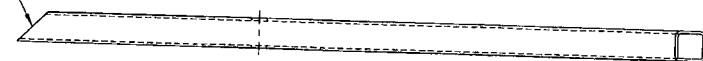
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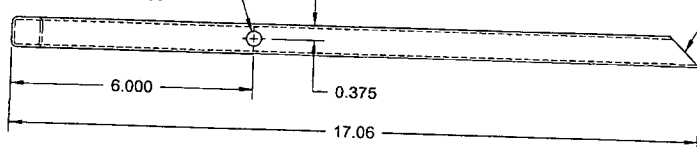
NOTE: Date & initial all entries

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CHAMFER

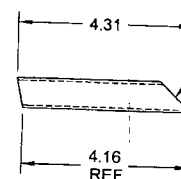


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0.75 X 45°
CHAMFER



D3836-1 RIB



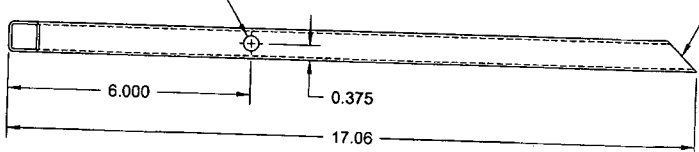
D3836-3 RIB

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CHAMFER

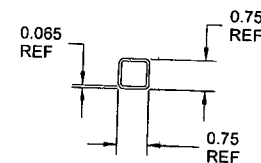


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/24

60908

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3836
MFG. APPR.		REV. A
APPROVED		SHEET 3 OF 3
DE APPR.		TITLE RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE NTS
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